

Date: Thursday, 6/29/2006 3:51:30 PM  
 User: Kim Johnston

## Process Sheet

SQLIT

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BUSHING  
 Job Number : 27785 A  
 Estimate Number : 10689  
 P.O. Number : N/A  
 This Issue : 6/29/2006 S.O. No. : N/A  
 Prsht Rev. : NC  
 First Issue : N/A Type : MACHINED PARTS  
 Previous Run : 24910  
 Part Number : D34543  
 Drawing Number : D3454 REV ~~KB~~  
 Project Number : N/A  
 Drawing Revision : ~~KB~~  
 Material : N/A  
 Due Date : 7/12/2006  
 Qty: 2 Um: 12 Each  
 Written By : JRE COMMENT Below  
 Checked & Approved By : RJ 06.06.29  
 Comment : est rev. A 05.11.17 new issue EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M303R0750 303 Round Bar .75"



Comment: Qty.: 0.0630 f(s)/Unit Total: 0.7560 f(s)  
 303 Round Bar .75"  
 (M303R0750)  
 Batch: 101540

BC 06.07.21 2

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL  
 1-TURN AS PER FOLIO FA571 & DWG D3454,  
 FOLIO REV: N/A  
 DWG REV: SB

2-DEBURR AS REQUIRED

BC 06.07.21 2

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

BC 06.07.21 2

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

J.G 06/07/21 2

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
 Deburr if necessary.

BC 06.07.21 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA:  Date: 06/07/21

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 27785

Part Number: D34543

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BG 06-07-21

2

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

*Handwritten signature and date: 6/27/21*

8.0

DC

DOCUMENT CONTROL



06/27/21

Comment: DOCUMENT CONTROL

Inspection Level 21

*Handwritten: 06-07-21*

Job Completion



*Handwritten: 06-07-21*



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
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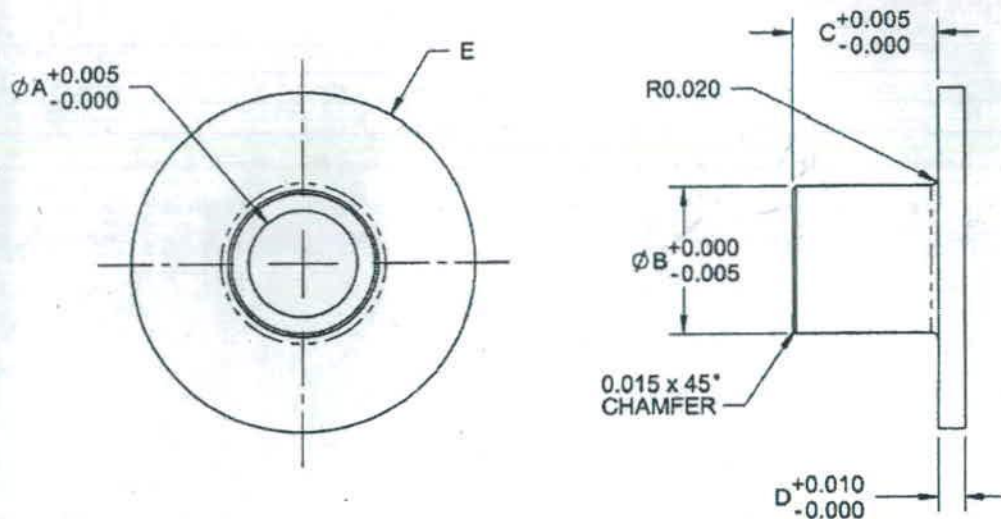
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

**DART**

DESIGN RF	DRAWN BY RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. <b>D3454</b>	REV. B SHEET 1 OF 1
DATE <b>05.12.05</b>	TITLE <b>BUSHING</b>		SCALE 2:1
A	05.09.02	NEW ISSUE	
B	05.12.05	REVISE -5/-7	

**RELEASED**05.12.05 *H***D3454-X**

1) SPECIFICATION: D3454-X BUSHING

DASH No.

WHERE 'X' IS THE SIZE PER THE FOLLOWING TABLE:

DASH No.	A (in)	B (in)	C (in)	D (in)	E (in)
-1	0.316	0.435	0.420	0.060	1.00
-3	0.316	0.435	0.400	0.060	0.75
-5	0.250	0.372	0.400	0.060	0.75
-7	0.250	0.372	0.343	0.060	0.75

**NOTES:**

- 1) MATERIAL: AISI 303 SS ROUND BAR (REF. DART SPEC. M303R)
- 2) FINISH: NONE
- 3) IDENTIFY WITH P/N USING FINE POINT PERMANENT MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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